

Date: Tuesday, 4/25/2006 7:35:20 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE
Job Number : 26790	
Estimate Number : 11555	
P.O. Number : N/A	Part Number : D30811
This Issue : 4/25/2006 S.O. No. : N/A	Drawing Number : D3081 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <i>SEE COMMENT BELOW</i>	Due Date : 5/5/2006 Qty: 10 Um: Each
Checked and Approved By : <i>06.04.25 N</i>	
Comment : Est A 0204.26 New Issue NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MS202575	HINGE
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Comment: Qty.: 2.6250 Each(s)/Unit Total : 26.2500 Each(s)

HINGE

Pick:

Qty Part number Description Batch

1 MS20257-5 Continous hinge 6ft

M100857

SAH 06.05.00

(10)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Cut hinge as per dwg (approx 26 pieces) and drill as per dwg D3081.

Deburr.

Bend hinge as per dwg D3081.

SAH 06.05.10

(10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06-06-19

4.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Break hinges immediately after powder coat.

SC

A.M. 06-06-29

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-06-29

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: Rec'd / Pass ^{NEP & Small} NCR: (Yes) No DQA: [Signature] Date: 06/07/05
 QA: N/C Closed: [Signature] Date: 06.07.05

NCR: <u>26790</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-30	20	All holes drilled to .257 Employee didn't look at Dwg properly	<u>[Signature]</u> <u>[Signature]</u>	Scrap: destroy all parts, and replace. Ensure Dwg is properly read.	SAN 06-05-30	<u>[Signature]</u> <u>[Signature]</u>	<u>[Signature]</u> <u>[Signature]</u>	<u>[Signature]</u> 06-05-30

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:35:21 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 26790

Part Number: D30811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 405

H.M

06-06-30

(1D)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/05

Job Completion



U 06-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

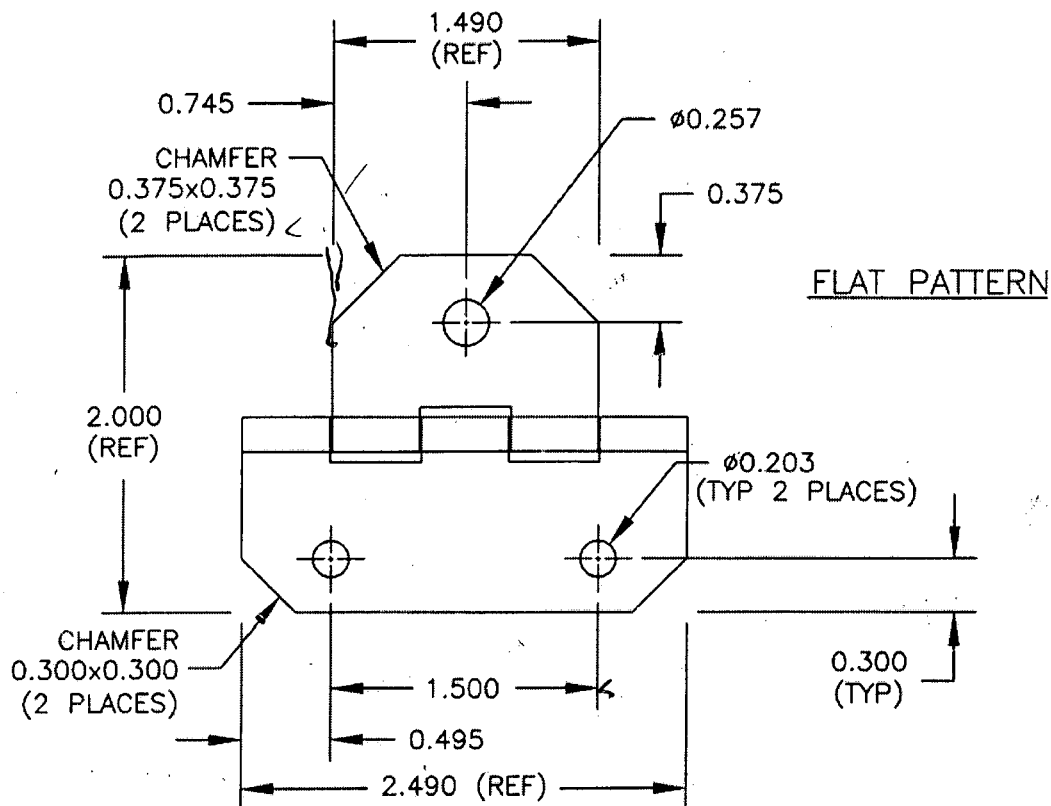
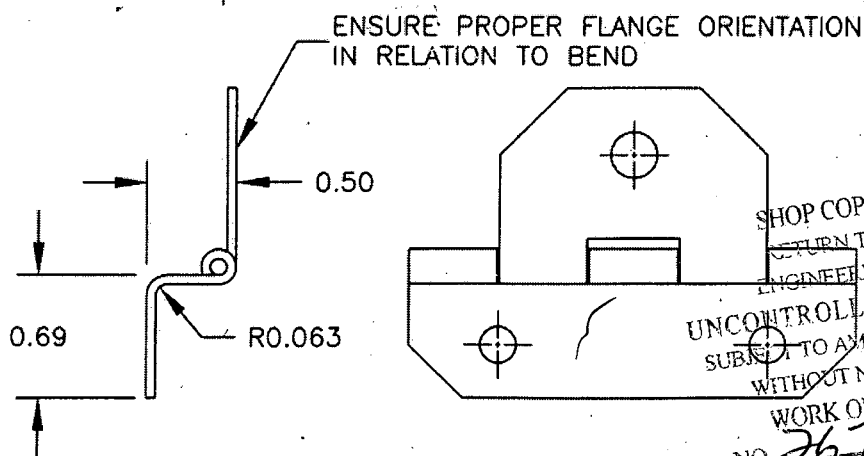
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3081	REV. A SHEET 1 OF 1
DATE 02.01.18		TITLE HINGE	SCALE 1:1
A	02.01.18	NEW ISSUE	

**BENDING DETAIL****D3081-1 HINGE**

MAKE FROM MS20257-5 CONTINUOUS HINGE

BREAK SHARP EDGES 0.015 MAX

FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBMIT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26790

RELEASED
02.01.25

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